

Work Order ID 154221

154221

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Tuesday, December 06, 2016 2:50:50 PM

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Bracket
 Start Date: 11/30/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 12/6/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: DEC 07 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2583	Rev B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.07							
FLOW CNC Waterjet	1-Cut as per Dwg D2583 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.03							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.07							
Quality Control									

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DEC 09 2016

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QC: _____ Date: _____ SPC (Y/N): _____

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.01				DAS 30 9-89			DEC 14 2016
	Memo	0.07							
	DeburrForm on CNC Brake as per Dwg D2583								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				20			DAS 38 9-89 DEC 14 2016
	Memo	0.07							
	Quality Control								
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				x20			2016/12/16 BEB
	Memo	0.07							
	Hand Finishing								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 136/113</i> Memo START TIME: <i>3:40</i> OVEN TEMPERATURE: <i>200</i> FINISH TIME: <i>N: 10</i>	0.00 0.03				<i>20</i>	<i>0</i>	<i>16-12-19</i>	<i>19</i> <i>353</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				<i>25</i>	<i>16-12-20</i>		<i>DAS</i> <i>9</i> <i>9-89</i>
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>5481</i> Memo	0.00 0.03				<i>25</i>			<i>DA</i> <i>6</i> <i>9-89</i>

DEC 21 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.33							
Quality Control									

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Picklist Print

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Work Order ID: 154221

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Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	55.0137	0.1169	2.461053			

M5052H32S 040

5052-H32 .040 Sheet

Dec 16 / 12 / 08

Location

Loc Qty

Loc Code

MAT

7.7

m135512

7.7

MAT022

18.9

m134774

18.9

MAT023

28.413684

m1342217

1.313684

m134617

2.1

m136102

25

3.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

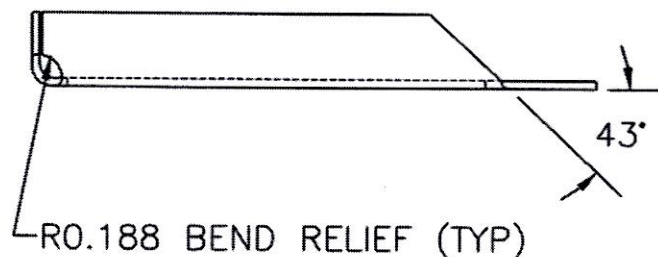
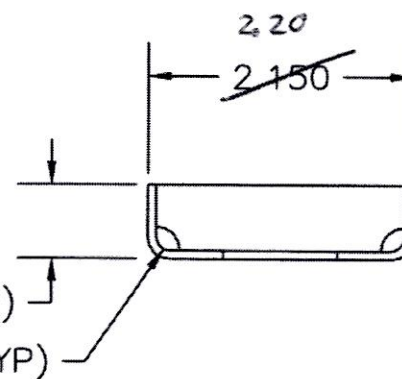
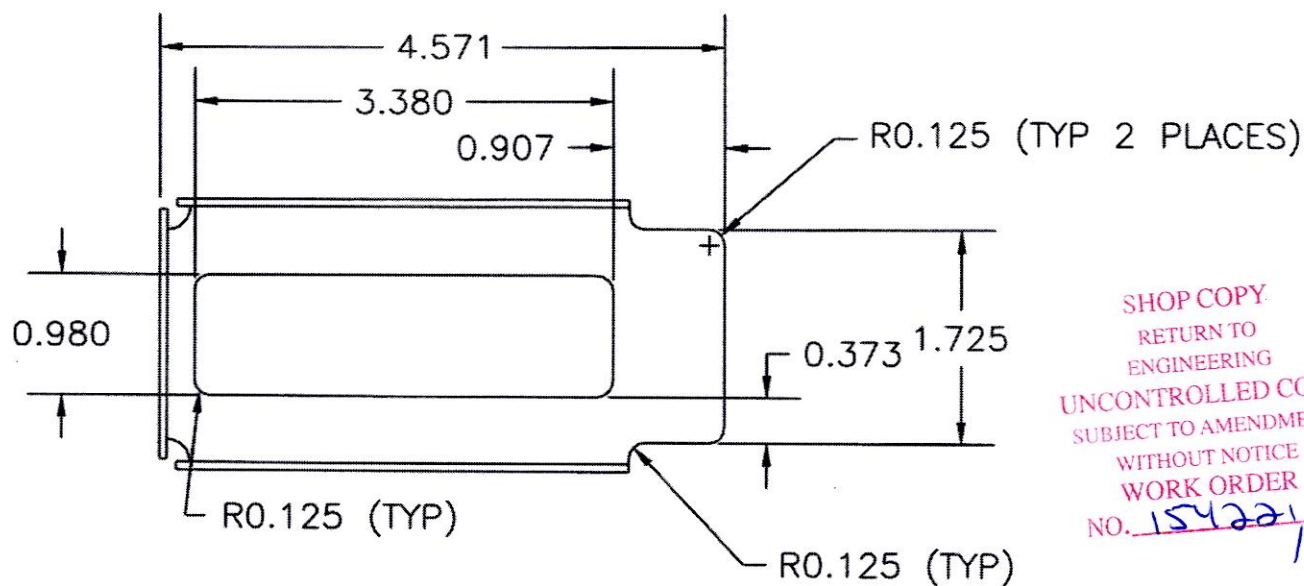
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				

DART**RELEASED**
KE 99.02.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154221 415
16-12-07
KE 99.02.26



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M.		RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
CP	KE	D2583		SHEET 1 OF 1	
DATE		TITLE		SCALE	
99.02.22		LATCH BRACKET		2:3	
A	96.07.10	NEW ISSUE			
B	99.02.22	CHANGE OF FINISH (PER TSR A887)			